

Work Order ID 103208

June-19-13 8:50:16 AM

103208

Asap

Page 1

Item ID: D3879-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Baggage Protector-wall

Stop

NS2

Start Date: 6/19/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 7/03/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: M5

Date: 13-06-19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3879 | Rev B |

100

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3879

Dwg Rev: B

Prog Rev: B

2- Deburr if necessary

2 0

Ae

13-10-08

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

2 0

Ae

13-10-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

| | | | | | | | | | |
|-------------------|---|--|------------------------------------|--|--------------------------------------|--|--|--|--|
| Work Order: _____ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| NCR No. _____ | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | | | | | | | | |
|---|---|--|---|---|--|--|--|--|--|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Pressure/Forced | | | | | | |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Set-up | | | | | | |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect | <input type="checkbox"/> Temperature/Cure | | | | | | |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing | <input type="checkbox"/> Weld | | | | | | |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved | <input type="checkbox"/> Wrong Stock Pulled | | | | | | |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong | <input type="checkbox"/> Other | | | | | | |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge | | | | | | | |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | | | | | | | | |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | | | | | | | | |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | | | | | | | | |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | | | | | | | | |

Work Order ID 103208

June-19-13 8:50:16 AM

103208

Page 2

Item ID: D3879-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Baggage Protector-wall

Stop

NS2

Start Date: 6/19/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/03/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

120

QC

Memo

0.00

9-89

Quality Control

13109

130

Identify as per dwg & Stock Location: _____

0.00

DAS

32

9-89

130

Packaging

Memo

PIP 108142 0.00

20

13/10/9

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

13/10/10
MF

13-10-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | | | |
|--------------------------|----------------------|--------------------------|-----------------------------------|--------------------------|--------------------|
| Bending | Bend | <input type="checkbox"/> | Folio/Program | <input type="checkbox"/> | Pressure/Forced |
| Centre Not Concentric | BOM/Route | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Set-up |
| Cracks | Broken/Damage/Defect | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Temperature/Cure |
| Crimp/Kink/Ripple/Wave | Burrs | <input type="checkbox"/> | Inspection Incomplete/Unqualified | <input type="checkbox"/> | Weld |
| Cuffs | Contamination | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Wrong Stock Pulled |
| Crushing | Countersink | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> | |
| Heat Treat | Cut Too Short | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Other |
| Inspection Strip in Tube | Drawing | <input type="checkbox"/> | Misread | <input type="checkbox"/> | |
| Marks/Chatter | Drill Holes | <input type="checkbox"/> | Off-set | <input type="checkbox"/> | |
| Turning Sequence | Finish | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> | |
| Wave/Twist in Tube | Fit/Function | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | |

Picklist Print

June-19-13 8:50:19 AM

Page 1/1

Work Order ID: 103208

103208

Parent Item: D3879-1

D3879-1

Parent Item Name: Baggage Protector-wall

Start Date: 6/19/13

Required Date: 7/03/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.125-F60029-04 | | Purchased | No | | | 100 | sf | 1,238.362 | 7.35 | 14.7 | | | |

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

| Location | Loc Qty | Loc Code |
|----------|----------|----------|
| MAT018 | 1238.362 | |
| 124866 | 1238.362 | |

Ac 13.10.08

m126425 → 14.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| | | | | | | | |
|-------------------|---|--|------------------------------------|--|--------------------------------------|--|--|
| Work Order: _____ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | |
| NCR No. _____ | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | |
| | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | |
| | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | |
|----------------|---|---|--|---|---|--|--|--|--|
| Landing Gear | General | | | | | | | | |
| | <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Pressure/Forced | | | | |
| | <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Set-up | | | | |
| | <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect | <input type="checkbox"/> Temperature/Cure | | | | |
| | <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing | <input type="checkbox"/> Weld | | | | |
| | <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved | <input type="checkbox"/> Wrong Stock Pulled | | | | |
| | <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong | <input type="checkbox"/> Other | | | | |
| | <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge | | | | | |
| | <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | | | | | | |
| | <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | | | | | | |
| | <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | | | | | | |
| | <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | | | | | | |

| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 103708 |
| Description: Cargo Wall Protector | Part Number: | D3879-1 |
| Inspection Dwg: D3879 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

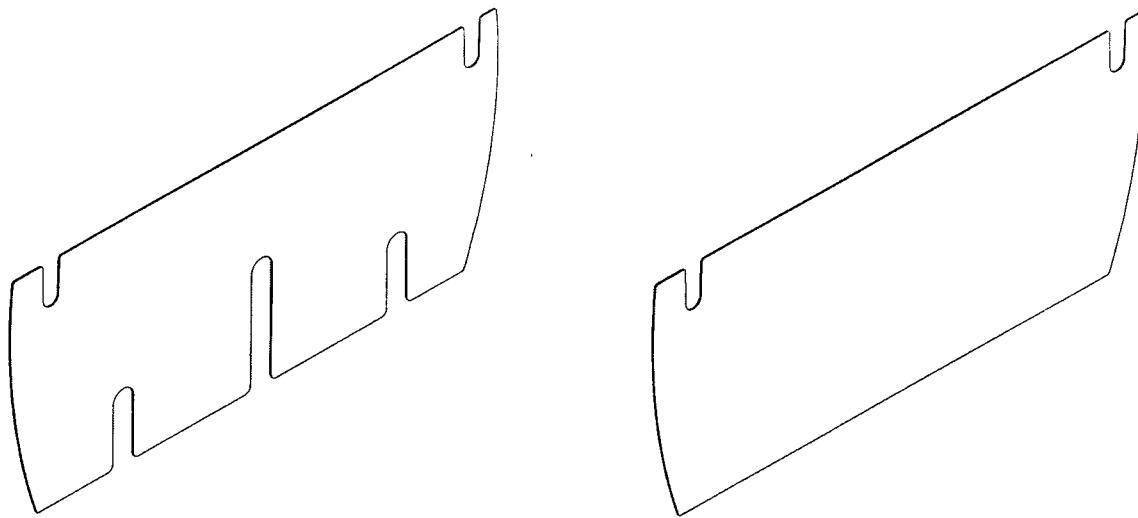
X First Article Prototype

26

2

| | | | | | |
|--------------|-----------|-------------|----------------|---------------------|-----|
| Measured by: | <i>Ac</i> | Audited by: | 9-89 | Prototype Approval: | N/A |
| Date: | 13.10.08 | Date: | <i>13.10.9</i> | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 09.10.16 | New Issue | KJ | |



D3879-1 CARGO WALL PROTECTOR
(BELL 206 A/B)

D3879-3 CARGO WALL PROTECTOR
(BELL 206 L/L1/L3/L4, 407)

103208 MCJ
13-06-19

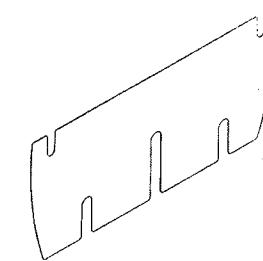
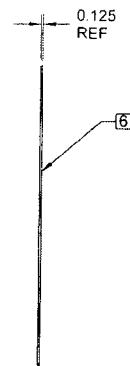
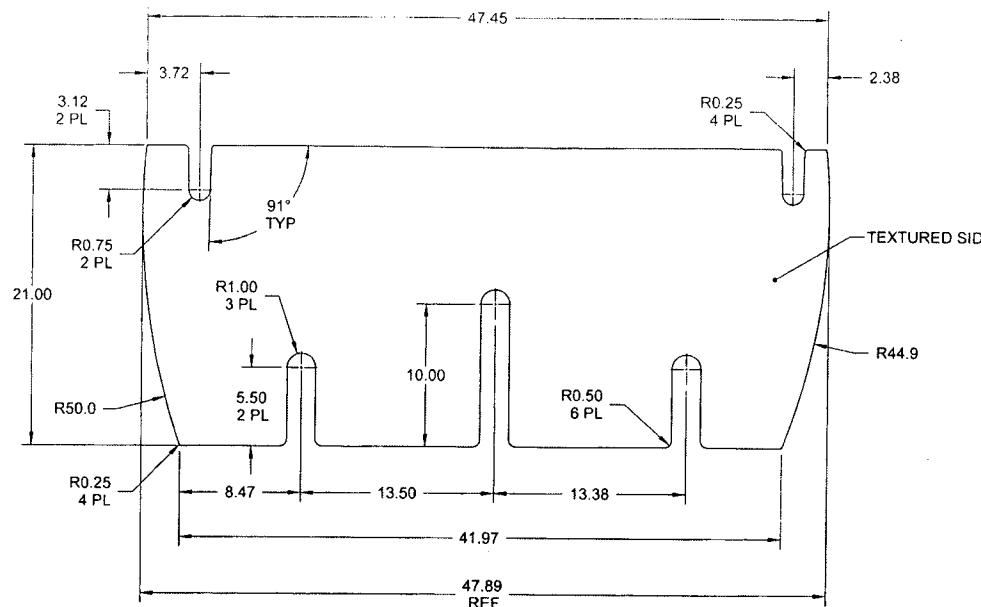
RELEASED
(29/06/12 MCJ)

| | | | | |
|------------|--|--|-----------------------------|----------|
| B | ADD D3879-3 CARGO WALL PROTECTOR (SHEET 3); ADD GY3778 TO MATERIAL SPECIFICATION (ZN A8-2) | | PH | 09.05.14 |
| A | NEW ISSUE | | PH | 09.02.04 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | PH | DRAWING NO. | REV. B | |
| CHECKED | | D3879 | SHEET 1 OF 3 | |
| MFG. APPR. | | APPROVED | TITLE | |
| DE APPR. | | | SCALE | |
| DATE | 09.05.14 | | CARGO WALL PROTECTOR | |
| | | | NTS | |

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8 7 6 5 4 3 2 1

103208



D3879-1 CARGO WALL PROTECTOR
(BELL 206 A/B)

RELEASED
09/06/14 MP

NOTES:

1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
(REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

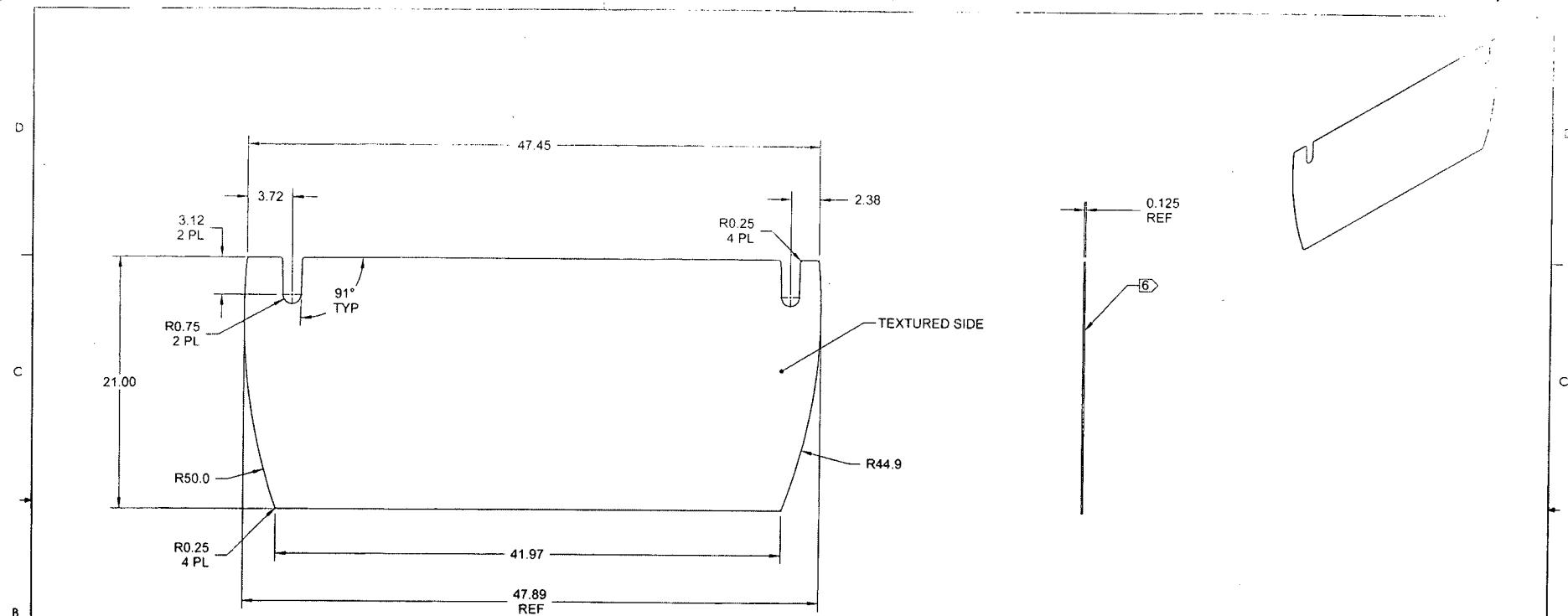
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3879-1" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE

7) WEIGHT: 4.81 lbs

| | | |
|------------|----------|---|
| DESIGN | PT | DART AEROSPACE LTD |
| DRAWN | PT | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. |
| MFG. APPR. | | REV. B |
| APPROVED | | D3879 |
| DE APPR. | | SHEET 2 OF 3 |
| DATE | 09.05.14 | TITLE |
| | | SCALE |
| | | CARGO WALL PROTECTOR |
| | | NTS |
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8 7 6 5 4 3 2 1

103208



D3879-3 CARGO WALL PROTECTOR
(BELL 206 L/L1/L3/L4, 407)

NOTES:

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3879-3" USING FINE POINT PERMANENT INK MARKER OR LABEL ON SMOOTH SIDE
- 7) WEIGHT: 5.06 lbs

8 7 6 5 4 3 2 1

| | | |
|------------|----------|-----------------------------|
| DESIGN | PH | DART AEROSPACE LTD |
| DRAWN | PH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | REV. B |
| MFG. APPR. | | D3879 SHEET 3 OF 3 |
| APPROVED | | TITLE |
| DE APPR. | | SCALE |
| DATE | 09.05.14 | CARGO WALL PROTECTOR NTS |

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RELEASED
07/01/14